

MREX20 Installation Instructions

The MREX20 installation will be the same for all models of the MREX20 family. This install is similar to the original MREX MkII, with the addition of a second bridge insert. Unlike the MkII the bridges are not pre-installed; this process will need to be followed carefully to prevent damage to the bridge and ensure proper alignment of the rail. Anyone with an understanding of general maintenance of a SCAR can successfully complete this installation on their own, and we encourage you to do so! Be sure the firearm is unloaded and all ammo is away from your workspace, we want to make sure you can enjoy your new rail!

Difficulty level: 5/10

Inside the Box:

- 1 - MREX20
- 3 - M5-0.8x12mm fasteners
- 2 - M5-0.8x8mm fasteners
- 2- Custom centering fasteners
- 2- Bridges
- 1 - T25 Torx wrench
- Vibra-tite or equivalent

Tools you will need:

- Torque wrench + T25 bit (If you do not want to use the one provided)
- Metric 2.5mm HEX bit (not included)
- Heat gun, soldering iron, or wood burner (Optional but might help a lot)
- Tender love and care, patience & your thinking cap

The majority of this installation will be explained with the rifle turned upside down, resting on the top picatinny rail

Preparing your rifle:

1. Start by removing the lower receiver, stock, buffer & spring, charging handle, and bolt carrier group assembly.
2. Remove the left and right side front picatinny rail segments: There are six 2.5mm hex head fasteners and two T25 fasteners that will need to be removed. Set all components aside and keep.
3. Remove the barrel assembly: Loosen and completely back out the six T25 fasteners holding the barrel in place (These fasteners will stay in place on the firearm).
4. Next, slide the barrel assembly forward, then up and out of the upper receiver.
5. Remove the lower picatinny rail from the barrel: Carefully apply heat to the T25 fastener under the barrel's chamber and carefully remove the fastener and rail section. Set aside and keep. (This fastener is tight so use heat and caution)
6. Remove the OEM bridge inserts from the upper receiver. Set aside and keep.
7. Place the barrel assembly back down into the receiver and slide rearward into place BUT do not tighten the barrel screws! (Leaving these loose will help when installing the rear bridge)

Installing bridge assemblies:

*Note: The directional arrows engraved on the bridges will **point at each other**.*

1. Slide the first bridge into the inner channel in the front of the receiver. Align the threaded holes in the bridge with the forwardmost holes in the receiver (The arrow should be pointed towards the rear of the firearm)
2. Take the second bridge and one custom centering fastener: Thread the custom fastener into the top of the second bridge. Tighten finger tight! (This will be used as a handle to aid in the installation of this bridge)
3. With the arrow pointing towards the first bridge: Insert the second bridge into the opening of the receiver, just in front of the barrel trunnion nut.
4. Carefully slide the bridge forwards down the inner track until the threaded holes in the side of the bridge are centered with the large, rear-most, holes in the side of the receiver. (With the barrel screws loose, you can flex the receiver open slightly to assist moving the bridge into place. Use the custom fastener as a handle to help move the bridge along the inner track)
5. Remove the customer fastener from the top of the bridge, previously installed in step 2
6. To ensure proper bridge alignment we will use both customer centering fasteners to center the bridge in the receiver and temporarily hold the bridge in place.
 - a. Carefully, and evenly, start to thread the customer fasteners into each side of the bridge
 - b. Use the fasteners as handles to move and adjust the bridge as necessary.
 - c. Continue to tighten each until the enlarged portion of the centering fastener enters through the holes in the side of the receiver
 - d. Once both fasteners are evenly inside the holes of the receiver; tighten finger tight
7. With the customer fasteners now holding the bridge firmly in place: tighten the six barrel screws to the factory recommended 62 in/lb using a criss crossing pattern
8. Without disturbing the bridge: Remove the custom fasteners from the sides of the receiver.

Installing the MREX20:

1. Place the MREX20 down onto the rifle, ensuring all holes are equally aligned. (Adjust the front bridge as necessary. The rear bridge should not need to be adjusted)
- Note: Apply a small amount of loctite to each fastener's threads before installing*
2. Install both customer fasteners into the sides of the rear bridge. Tighten finger tight
 3. Install the smaller 8mm fastener into the top of the rear bridge. Tighten finger tight
 4. Install a 12mm fastener in the rear most mounting hole, affixing the rail to the barrel assembly. Tighten finger tight
 5. Install the two remaining 12mm fasteners in the sides of the front bridge. Tighten finger tight
 6. Install the final 8mm fastener into the top of the front bridge. Tighten finger tight
 7. Set torque wrench to 35in/lb and follow torque pattern below:
 - a. Left then right rear bridge custom centering fasteners
 - b. Rear bridge 8mm fastener
 - c. Rear most 12mm Barrel fastener
 - d. Right then left front bridge 12mm fasteners
 - e. Front Bridge 8mm fastener
 8. Set torque wrench to 62in/lb then repeat torque pattern

Congrats! You now got yourself one badass Scar 20s

